

Date: Thursday, 11/12/2008 10:15:52 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB ASSY (INBOARD)
Job Number	: 44011		
Estimate Number	: 13661		
P.O. Number	:	Part Number	: D3827041
This Issue	: 11/12/2008 S.O. No. :	Drawing Number	: D3827 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>3008.12.11</u>		
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bushing

batch: 77110335 B 44059

SP 09.01.08

~~SAD 08-12-30~~

8

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 8.4000 f(s)/Unit Total: 67.2000 f(s)

304 SQ Tube .75x.75x.065W

batch: 77110335

SAD 08-12-30

8

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3827-1 rib as per dwg D3827

2- drill holes as per dwg D3827 using DT9435 jig

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 08-12-31

(8)

SAD 09-01-07 (8)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 09-01-07 (8)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- weld bushing in rib as per dwg D3827

A/R ER316 S.S. Rod Batch: 771106762

SP 09/01/08

(8)

SP 09.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:15:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 44011

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 09/01/08

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/08 (LB)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *BASKET CELL*

JS 09/01/08

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(e)

12/05/01/09

Job Completion



MF 09-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

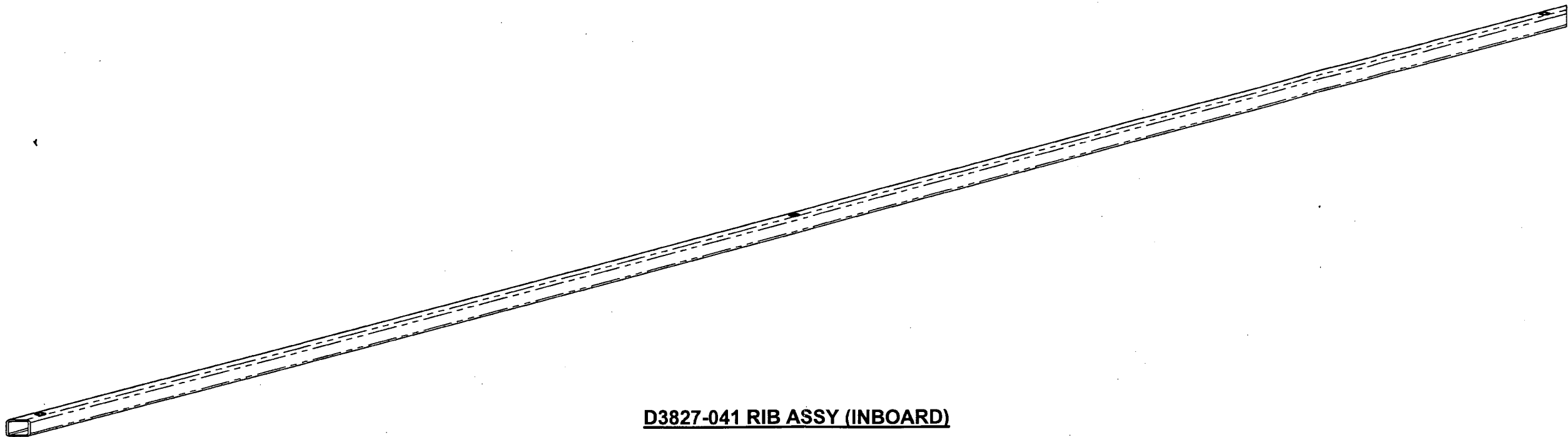
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
DATE	08.09.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8 7 6 5 4 3 2 1

D

D

C

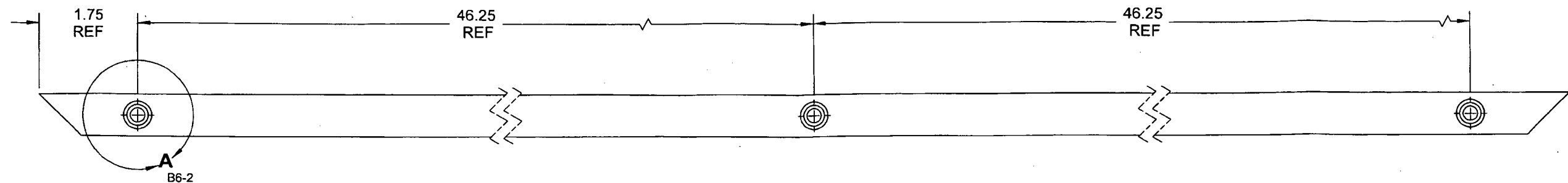
C

B

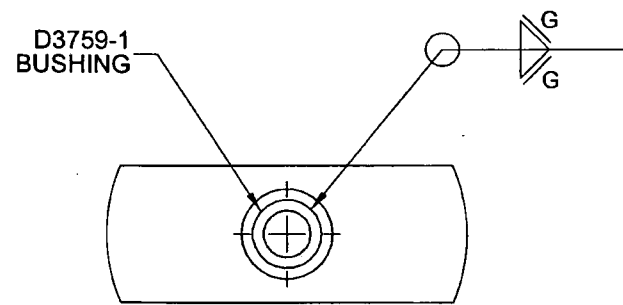
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A

A






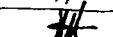
D3827-041 RIB ASSY (INBOARD)



DETAIL A
SCALE 2X
3 PL

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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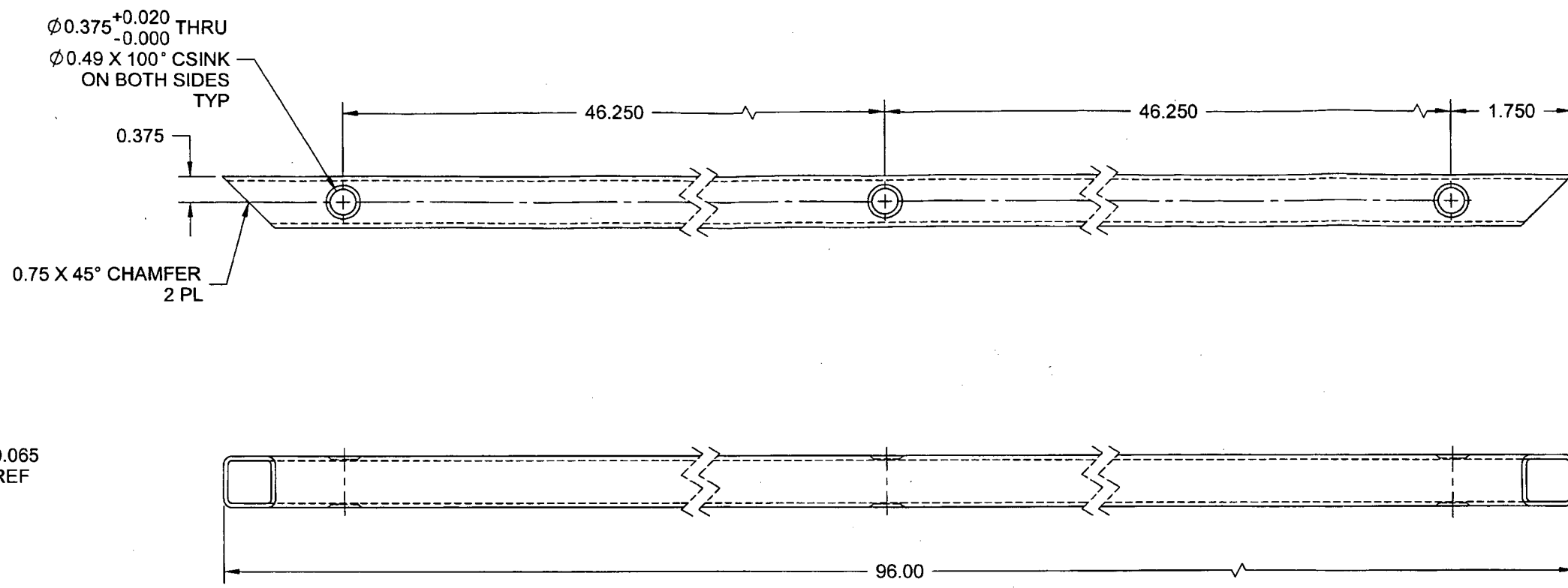
C

B

B

A

A



D3827-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

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8 7 6 5 4 3 2 1

